

Film for Fastening Cargo during Transportation and Method for  
Fastening Cargo Using the Same

BACKGROUND OF THE INVENTION

5

1. Field of the Invention

The present invention relates to a film for fastening cargo during transportation, and more specifically to a protective film that has a low percentage strain change, and has excellent ability  
10 to hold/fasten products. The present invention also relates to a method for fastening cargo using the film.

2. Description of the Related Art

Fastening film is used for the purpose of holding/fastening products (cargo) during transportation with a method in which the  
15 products are fastened directly in corrugated cardboard, or a method in which the products are held in a midair state sandwiched between a pair of films. Because the purpose of fastening film is to hold/fasten products during transportation, the fastening film is required to have properties such that the products are not subjected  
20 to shock and are not damaged. Moreover, fastening film is used throughout the year over a broad temperature range, and the properties in a normal temperature range in which usage is common (around 23°C) and in a high temperature range in which the film stretches easily (above 50°C) are particularly important.

25 Fastening films used from hitherto include resin films made of EVA, urethane resins and so on.

With such a fastening film, the elastic modulus and the percentage strain change are high, with the elastic modulus exceeding 60MPa and the percentage strain change exceeding 2.0% at 23°C, and the elastic modulus being at least 20MPa and the percentage strain change being at least 2.5% at 55°C, and hence it is difficult to stabilize products with the fastening film not fitting to the products during transportation, and thus problems arise such as the products being damaged. There are thus calls for a film having a low percentage strain change at 23°C and 55°C.

Amid this state of affairs, a film that uses a urethane resin and is used in a state of suspension in which a computer product or the like is sandwiched in midair has been proposed (U.S. Patent No. 6148591). Moreover, a film of an ethylene-styrene random copolymer has also been proposed (WO 98/10014).

However, in these patent documents, there is no mention whatsoever of the percentage strain change at certain temperatures.

The advent of a film that has a low percentage strain change at certain temperatures, preferably has a low elastic modulus, and has excellent ability to hold/fasten products during transportation is thus desired.

#### SUMMARY OF THE INVENTION

It is an object of the present invention to resolve problems of the prior art as described above, and to provide a film for fastening cargo during transportation that has a low percentage strain change compared with films made of EVA or a urethane resin.

A film for fastening cargo during transportation according to the present invention is characterized in that a percentage strain change 100 hours after applying a load of 3.5MPa at a temperature of 23°C is not more than 2.0%, and a percentage strain change 100 hours after applying a load of 0.5MPa at a temperature of 55°C is not more than 2.5%. It is preferable for the film for fastening cargo during transportation to have an elastic modulus of not more than 60MPa at a temperature of 23°C, and an elastic modulus of not more than 20MPa at a temperature of 55°C.

Specifically, such film preferably contains at least one substantially random interpolymer comprising:

(1) 1 to 99mol% of polymer units derived from

(a) at least one aromatic vinyl or vinylidene monomer, or

(b) at least one hindered aliphatic or cycloaliphatic vinyl

or vinylidene monomer, or

(c) a combination of at least one aromatic vinyl or vinylidene monomer, and at least one hindered aliphatic or cycloaliphatic vinyl or vinylidene monomer, and

(2) 1 to 99mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 20 carbon atoms.

As such an interpolymer, it is preferable to use a substantially random interpolymer comprising 5 to 65mol% of polymer units derived from at least one aromatic vinyl or vinylidene monomer, and 35 to 95mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 20 carbon atoms, and it is particularly preferable to use a substantially random interpolymer comprising

5 to 65mol% of polymer units derived from styrene, and 35 to 95mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 10 carbon atoms.

Moreover, as such an interpolymer, it is preferable to use  
5 a pseudo-random interpolymer comprising 5 to 50mol% of polymer units derived from at least one aromatic vinyl or vinylidene monomer, and 50 to 95mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 20 carbon atoms, and it is particularly preferable to use a pseudo-random interpolymer comprising 5 to  
10 50mol% of polymer units derived from styrene, and 50 to 95mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 10 carbon atoms.

Here, as disclosed in Japanese Patent Application Laid-open No. 7-070223, 'pseudo' in 'pseudo-random interpolymer' means that  
15 there are no homopolymer segments comprising a vinyl or vinylidene monomer in the interpolymer molecular structure. That is, in a pseudo-random interpolymer, insertion of a vinyl or vinylidene monomer from head to head or from head to tail does not occur.

Another object of the present invention is to provide a method  
20 for fastening cargo using the films described above.

#### DESCRIPTION OF THE PREFERRED EMBODIMENTS

Following is a concrete description of the film for fastening cargo during transportation according to the present invention.

As mentioned above, the film for fastening cargo during  
25 transportation according to the present invention contains at least one substantially random interpolymer.

## Interpolymers

An interpolymer that can be used in the present invention is a substantially random interpolymer comprising

(1) 1 to 99mol% of polymer units derived from

5 (a) at least one aromatic vinyl or vinylidene monomer, or

(b) at least one hindered aliphatic or cycloaliphatic vinyl or vinylidene monomer, or

(c) a combination of at least one aromatic vinyl or vinylidene monomer, and at least one hindered aliphatic or cycloaliphatic  
10 vinyl or vinylidene monomer, and

(2) 1 to 99mol% of polymer units derived from at least one  $\alpha$ -olefin having 2 to 20 carbon atoms.

The term 'interpolymer' used here means a copolymer in the case of polymerizing at least two monomers to form an interpolymer.

15 'Copolymer' used here means a polymer in the case of polymerizing at least two monomers to form a copolymer.

'Substantially random' used here in the substantially random interpolymer comprising  $\alpha$ -olefin(s), and aromatic vinyl monomer(s), aromatic vinylidene monomer(s), hindered aliphatic  
20 vinyl monomer(s), hindered cycloaliphatic vinyl monomer(s), hindered aliphatic vinylidene monomer(s) or hindered cycloaliphatic vinylidene monomer(s) means that the monomer distribution in the interpolymer can be described by a 'Bernoulli statistical model' or by a 'first or second order Markovian  
25 statistical model', as described by J.C. Randall on pages 71 to 78 of 'Polymer Sequence Determination, Carbon-13 NMR Method'

published in 1977 by Academic Press, New York.

Preferably, a substantially random interpolymer comprising at least one  $\alpha$ -olefin having 2 to 20 carbon atoms and an aromatic vinyl or vinylidene monomer contains blocks of more than 3 aromatic vinyl or vinylidene monomer units (e.g. styrene monomer units of 4 or more repeat units derived from styrene) in an amount of not more than 15% of the total amount of aromatic vinyl or vinylidene monomer units. More preferably, this interpolymer cannot be characterized by a high degree of isotacticity or syndiotacticity. This means that in the  $^{13}\text{C}$  NMR spectrum of the substantially random interpolymer, the peak area corresponding to main chain methylene and methine carbons that exhibit either a meso diad sequence or a racemic diad sequence should not exceed 75% of the total peak area for main chain methylene and methine carbons.

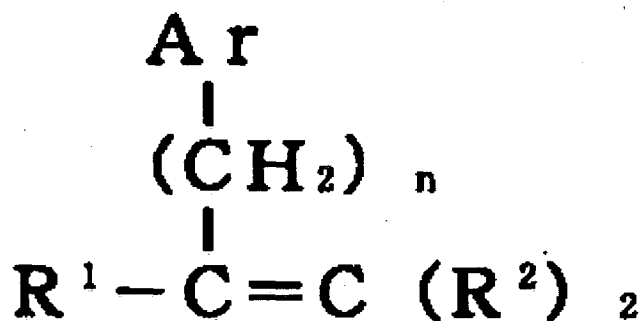
Interpolymers suitable for use in the present invention include interpolymers obtained by polymerizing at least one  $\alpha$ -olefin with at least one aromatic vinyl or vinylidene monomer and/or at least one hindered aliphatic or cycloaliphatic vinyl or vinylidene monomer, although there is no limitation thereto.

Examples of preferable  $\alpha$ -olefins are  $\alpha$ -olefins having 2 to 20 carbon atoms, preferably 2 to 12, more preferably 2 to 8. Out of these, ethylene, propylene, 1-butene, 4-methyl-1-pentene, 1-hexene, and 1-octene are particularly preferable. These  $\alpha$ -olefins do not contain aromatic groups.

Examples of aromatic vinyl or vinylidene monomers suitable for use in the manufacture of an interpolymer that can be used in

the present invention include monomers represented by the following formula.

5



In this formula,  $\text{R}^1$  is an atom or group selected from the group consisting of a hydrogen atom and alkyl groups having 1 to 4 carbon atoms, and is preferably a hydrogen atom or a methyl group.

Each  $\text{R}^2$  is independently an atom or group selected from the  
10 group consisting of a hydrogen atom and alkyl groups having 1 to 4 carbon atoms, and is preferably a hydrogen atom or a methyl group.

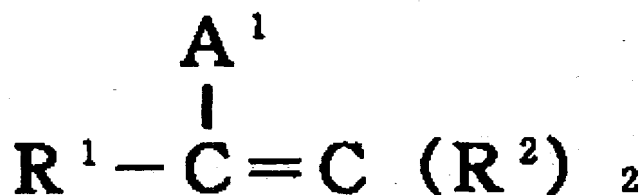
Ar is a phenyl group, or a phenyl group substituted with 1 to 5 substituents selected from the group consisting of halogen atoms, alkyl groups having 1 to 4 carbon atoms, and haloalkyl groups  
15 having 1 to 4 carbon atoms.

$n$  is an integer from 0 to 4, preferably 0 to 2, most preferably 0.

Specific examples of aromatic monovinyl or monovinylidene monomers are styrene, vinyltoluene,  $\alpha$ -methylstyrene, t-  
20 butylstyrene, chlorostyrene, and so on, with all isomers thereof

being included. Particularly preferable aromatic monovinyl or monovinylidene monomers are styrene, and lower alkyl- and halogen-substituted derivatives thereof. Preferable monomers are styrene,  $\alpha$ -methylstyrene, lower ( $C_{1-4}$ ) alkyl- and phenyl ring-substituted derivatives of styrene, for example ortho-, meta- and para-methylstyrene, ring-substituted styrene, and para-vinyltoluene, and also mixtures thereof. A particularly preferable aromatic monovinyl or monovinylidene monomer is styrene.

10 The previously mentioned term 'hindered aliphatic or cycloaliphatic vinyl or vinylidene compounds' means vinyl or vinylidene monomers capable of undergoing addition polymerization corresponding to compounds represented by the following formula.



15

In this formula,  $A^1$  is a sterically bulky aliphatic or cycloaliphatic substituent having no more than 20 carbon atoms.

$R^1$  is an atom or group selected from the group consisting of a hydrogen atom and alkyl groups having 1 to 4 carbon atoms, and is preferably a hydrogen atom or a methyl group.

Each  $R^2$  is independently an atom or group selected from the



group consisting of a hydrogen atom and alkyl groups having 1 to 4 carbon atoms, and is preferably a hydrogen atom or a methyl group.

$R^1$  and  $A^1$  may be combined to form a ring system.

'sterically bulky' above means that a monomer having such  
5 an aliphatic or cycloaliphatic substituent cannot undergo ordinary addition polymerization at a rate comparable with that of ethylene polymerization using a standard Ziegler-Natta catalyst.

Preferable hindered aliphatic or cycloaliphatic vinyl or vinylidene compounds are monomers that have an ethylenic  
10 unsaturated bond and have one carbon atom that has been subjected to tertiary or quaternary substitution. Examples of the substituents are cycloaliphatic groups such as cyclohexyl, cyclohexenyl and cyclooctenyl, and cyclic alkyl- and aryl-substituted derivatives thereof. The most preferable hindered  
15 aliphatic or cycloaliphatic vinyl or vinylidene compounds are various isomeric vinyl-substituted derivatives of cyclohexane and substituted cyclohexanes, and 5-ethylidene-2-norbornene. Particularly preferable are 1-, 3- and 4-vinylcyclohexene.

An interpolymer used in the present invention obtained by  
20 polymerizing at least one  $\alpha$ -olefin, and at least one aromatic vinyl or vinylidene monomer and/or at least one hindered aliphatic or cycloaliphatic vinyl or vinylidene monomer is a substantially random copolymer. Such interpolymers generally contain 1 to 99mol%, preferably 5 to 65mol%, more preferably 5 to 50mol%, of  
25 at least one aromatic vinyl or vinylidene monomer and/or at least one hindered aliphatic or cycloaliphatic vinyl or vinylidene

monomer, and 1 to 99mol%, preferably 35 to 95mol%, more preferably 50 to 95mol%, of at least one  $\alpha$ -olefin having 2 to 20 carbon atoms.

The number average molecular weight ( $M_n$ ) of the interpolymer is generally at least 10,000, preferably 20,000 to 1,000,000, more preferably 50,000 to 500,000.

Incidentally, during manufacture of such a substantially random interpolymer, a certain amount of an atactic aromatic vinyl or vinylidene homopolymer may be produced through homopolymerization of an aromatic vinyl or vinylidene monomer under heating. The presence of an aromatic vinyl or vinylidene homopolymer is in general undesirable in terms of the object of the present invention, and cannot be ignored. If desired, such an aromatic vinyl or vinylidene homopolymer can be separated from the interpolymer through an extraction technique in which, for example, either the interpolymer or the aromatic vinyl or vinylidene homopolymer is selectively precipitated from the solution using a nonsolvent therefor. In view of the object of the present invention, it is desirable for the amount present of an aromatic vinyl or vinylidene homopolymer to be not more than 20wt%, preferably not more than 15wt%, of the total amount of the interpolymer.

A substantially random interpolymer can be manufactured as described in U.S. Patent Application No. 07/545,403 filed on July 3, 1990 by James C. Stevens et al. (corresponding to EP-A-0,416,815), and U.S. Patent Application No. 08/469,828, which was filed on June 6, 1995 and was approved (U.S. Patent No. 5,703,187). All of the

disclosures in these U.S. Patent Applications are incorporated herein. Preferable operating conditions in the polymerization reaction of these U.S. Patent Applications are a pressure of atmospheric pressure to 3,000 atmospheres, and a temperature of  
5 -30 to 200°C. If polymerization and removal of unreacted monomers are carried out at a temperature higher than the automatic polymerization temperature of the respective monomers, then a certain amount of homopolymer polymerization products may be produced through free radical polymerization.

10 Examples of preferable catalysts and methods for manufacturing substantially random interpolymers that can be used in the present invention are disclosed in U.S. Patent Application No. 07/545,403, which was filed on July 3, 1990 and corresponds to EP-A-416,815; U.S. Patent Application No. 07/702,475, which was  
15 filed on May 20, 1991 and corresponds to EP-A-514,828; U.S. Patent Application No. 07/876,268, which was filed on May 1, 1992 and corresponds to EP-A-520,732; U.S. Patent Application No. 08/241,523, which was filed on May 12, 1994 (U.S. Patent No. 5,470,993); and U.S. Patents Nos. 5,055,438, 5,057,475, 5,096,867,  
20 5,064,802, 5,132,380, 5,189,192, 5,321,106, 5,347,024, 5,350,723, 5,374,696, 5,399,635, and 5,556,928. All of the disclosures therein are incorporated herein.

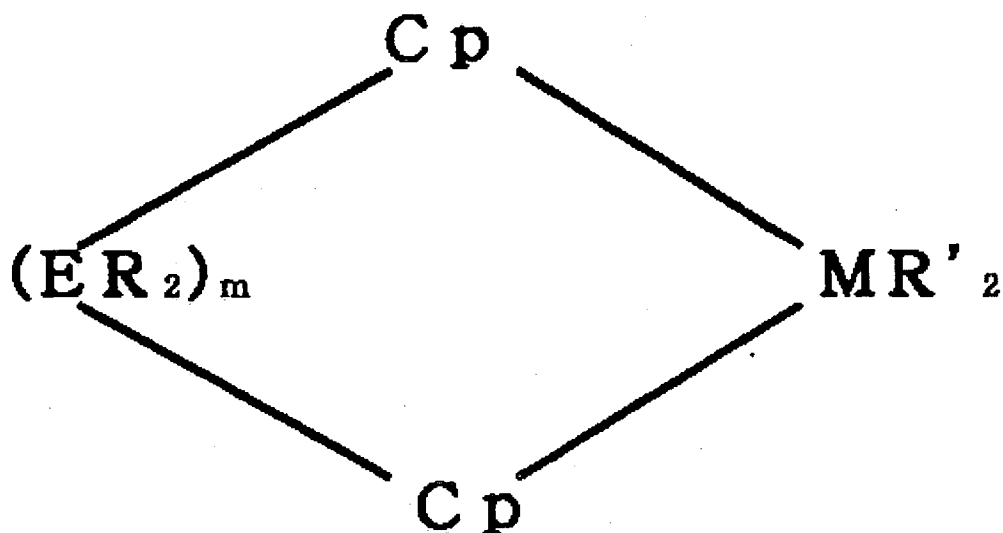
Substantially random  $\alpha$ -olefin / aromatic vinyl or vinylidene interpolymers that can be used in the present invention can also  
25 be manufactured using the method described in WO95/32095 by John C. Bradfute et al. (W.R. Grace & Co.), the method described in

WO94/00500 by R.B. Pannell (Exxon Chemical Patents, Inc.), and the method described on page 25 in 'Plastics Technology' (September 1992); all of the disclosures therein are incorporated herein as well.

5           Moreover, substantially random interpolymers comprising at least one  $\alpha$ -olefin / aromatic vinyl / aromatic vinyl /  $\alpha$ -olefin tetrad disclosed in U.S. Patent Application No. 08/708,809 filed on September 4, 1996 by Francis J. Timmers et al. (U.S. Patent No. 5,879,149) are also preferable. These interpolymers have  
10 additional signals having at least three times the intensity of a peak to peak noise ratio. These signals appear in the chemical shift ranges 43.75-44.25ppm and 38.0-38.5ppm. In particular, peaks are observed at 44.1, 43.9 and 38.2ppm. Proton test NMR experiments show that the signals in the 43.75-44.25ppm chemical  
15 shift range are methine carbons, and the signals in the 38.0-38.5ppm range are methylene carbons.

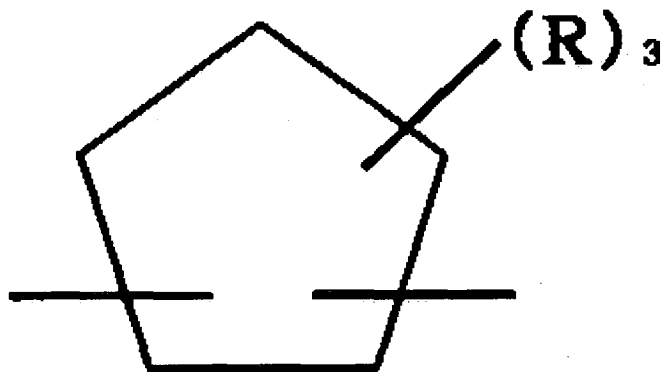
Pseudo-random interpolymers comprising an aliphatic  $\alpha$ -olefin and an aromatic monovinyl or monovinylidene compound that can be used in the present invention are disclosed in U.S. Patent  
20 Application No. 545403 filed on July 3, 1990 (corresponding to European Patent Application Laid-open No. 0416815).

These interpolymers can be manufactured by carrying out polymerization at a temperature in a range of -30 to 250°C in the presence of a catalyst represented by the following formula, and  
25 preferably a cocatalyst if desired.



Here, each Cp is independently a substituted  
 5 cyclopentadienyl group that is  $\pi$ -bonded to M, E is a carbon or  
 silicon atom, M is a group IV metal, preferably Zr or Hf, most  
 preferably Zr, each R is independently a hydrogen atom, or a  
 hydrocarbyl, silahydrocarbyl or hydrocarbylsilyl group having not  
 more than 30, preferably 1 to 20, more preferably 1 to 10, carbon  
 10 or silicon atoms, and each R' is independently a hydrogen atom,  
 a halogen atom, or a hydrocarbyl, hydrocarbyloxy, silahydrocarbyl  
 or hydrocarbylsilyl group having not more than 30, preferably 1  
 to 20, more preferably 1 to 10, carbon or silicon atoms, or the  
 two R' groups together form a  $\text{C}_{1-10}$  hydrocarbyl-substituted 1,3-  
 15 butadiene, and m is 1 or 2. Examples of particularly preferable  
 substituted cyclopentadienyl group are groups represented by the

following formula.



5            Here, each R is independently a hydrogen atom, or a hydrocarbyl, silahydrocarbyl or hydrocarbylsilyl group having not more than 30, preferably 1 to 20, more preferably 1 to 10, carbon or silicon atoms, or the two R groups together form a bivalent derivative thereof. Preferably, each R is independently hydrogen,  
10 methyl, ethyl, propyl, butyl, pentyl, hexyl, benzyl or phenyl (wherein in the case that isomers exist all of the isomers are included), or (if possible) the two R groups together form a fused ring system such as indenyl, fluorenyl, tetrahydroindenyl, tetrahydrofluorenyl or octahydrofluorenyl.

15            Specific examples of particularly preferable catalysts include racemic (dimethylsilanediyl)bis(2-methyl-4-phenylindenyl)zirconium dichloride, racemic (dimethylsilanediyl)bis(2-methyl-4-phenylindenyl)zirconium 1,4-diphenyl-1,3-butadiene, racemic (dimethylsilanediyl)bis(2-

methyl-4-phenylindenyl)zirconium di-C<sub>1-4</sub>-alkyls, racemic (dimethylsilanediyl)bis(2-methyl-4-phenylindenyl)zirconium di-C<sub>1-4</sub>-alkoxides, and combinations thereof.

Moreover, specific examples of titanium-based constrained geometry catalysts include [N-(1,1-dimethylethyl)-1,1-dimethyl-1-[(1,2,3,4,5- $\eta$ )-1,5,6,7-tetrahydro-s-indacen-1-yl]silaneaminato(2-)-N] titanium dimethyl, (1-indenyl)(t-butylamido)dimethylsilane titanium dimethyl, ((3-t-butyl)(1,2,3,4,5- $\eta$ )-1-indenyl)(t-butylamido)dimethylsilane titanium dimethyl, ((3-isopropyl)(1,2,3,4,5- $\eta$ )-1-indenyl)(t-butylamido)dimethylsilane titanium dimethyl, and combinations thereof.

Others method of manufacturing interpolymers that can be used in the present invention are described by Longo and Grassi (Makromol. Chem., Vol. 191, p2387-2396 (1990)) and D'Aniello et al. (Journal of Applied Polymer Science, Vol. 58, p1701-1706 (1995)); here, an ethylene-styrene copolymer is prepared using a methylaluminoxane (MAO) and cyclopentadienyl titanium trichloride (CpTiCl<sub>3</sub>) catalyst system. Moreover, Xu and Lin (Polymer Preprints, Am. Chem. Soc., Div. Polym. Chem., Vol. 35, p686-687 (1994)) have prepared a random copolymer between styrene and propylene using an MgCl<sub>2</sub>/TiCl<sub>4</sub>/NdCl<sub>3</sub>/Al(iBu)<sub>3</sub> catalyst. Furthermore, Lu et al. (Journal of Applied Polymer Science, Vol. 53, p1453-1460 (1994)) have reported on a copolymer between ethylene and styrene using a TiCl<sub>4</sub>/NdCl<sub>3</sub>/MgCl<sub>2</sub>/Al(Et)<sub>3</sub> catalyst.

Sernets and Mulhaupt (Macromol. Chem. Phys., v. 197, pp.

1071-1083, 1997) describe the effects of the polymerization conditions in the copolymerization of styrene and ethylene using an  $\text{Me}_2\text{Si}(\text{Me}_4\text{Cp})(\text{N-t-butyl})\text{TiCl}_2$ /methylaluminoxane Ziegler-Natta catalyst. Ethylene-styrene copolymers manufactured using a  
5 bridged metallocene catalyst are described by Arai, Toshiaki and Suzuki (Polymer Preprints, Am. Chem. Soc., Div. Polym. Chem., Vol. 38, p349-350, 1997) and in U.S. Patent No. 5,652,315 (Mitsui Toatsu Chemicals, Inc.). The manufacture of interpolymers comprising an  $\alpha$ -olefin and an aromatic vinyl monomer (e.g. propylene/styrene or  
10 butene/styrene) is described in U.S. Patent No. 5,244,996 (Mitsui Petrochemical Industries, Ltd.) and U.S. Patent No. 5,652,315 (Mitsui Petrochemical Industries, Ltd.), and is also described in German publication DE19711339A1, U.S. Patent No. 5,883,213 (Denki Kagaku Kogyo K.K.), and so on. The interpolymer component  
15 preparation methods disclosed in the above are incorporated into the present invention as reference documents. The ethylene/styrene random copolymer disclosed by Aria et al. in Polymer Preprints, Vol. 39, No. 1, March 1998 can also be used a component in the present invention.

20 Examples of suitable catalysts and methods for manufacturing pseudo-random interpolymers that are suitable for use in the present invention are disclosed in the specifications of U.S. Patent Application No. 545403 filed on July 3, 1990 (European Patent Application Laid-open No. 0416815), U.S. Patent Application No.  
25 547718 filed on July 3, 1990 (European Patent Application Laid-open No. 468651), U.S. Patent Application No. 702475 filed on May 20,



1991 (European Patent Application Laid-open No. 514828), U.S. Patent Application No. 876268 filed on May 1, 1992 (European Patent Application Laid-open No. 520732), U.S. Patent Application No. 8003 filed on January 21, 1993 (U.S. Patent No. 5,374,696), U.S. Patent Application No. 82197 filed on June 24, 1993 (corresponding to WO95/00526), and also U.S. Patent Application Nos. 5055438, 5057475, 5096867, 5064802, 5132380 and 5189192; all of these are cited as references for the present invention.

Film for fastening cargo during transportation

10 For a film for fastening cargo during transportation according to the present invention comprising such interpolymer(s), the percentage strain change 100 hours after applying a load of 3.5MPa at a temperature of 23°C is not more than 2.0%, preferably 1.4 to 1.7%, and the percentage strain change 100 hours after applying  
15 a load of 0.5MPa at a temperature of 55°C is not more than 2.5%, preferably 2.0 to 2.3%. Moreover, the film of the present invention preferably has an elastic modulus at a temperature of 23°C of not more than 60MPa, more preferably 10 to 30MPa, and preferably has an elastic modulus at a temperature of 55°C of not  
20 more than 20MPa, more preferably 1 to 10MPa. A film for which the percentage strain changes at temperatures of 23°C and 55°C are low as above has excellent ability to hold/fasten products (cargo) during transportation.

A specific method of measuring the elastic modulus and  
25 percentage strain changes will be described later in the 'Examples' section.

### Preparation of fastening film

The fastening film according to the present invention can be formed using a conventional publicly known method, for example using an extruder such as a calender apparatus, a T-die apparatus, 5 or an inflation apparatus. When forming the film, in addition to the interpolymers described above, additives such as antioxidants, ultraviolet absorbers, weather-resistant stabilizers, heat-resistant stabilizers, antistatic agents, fire retardants, pigments, dyes and slipping agents can be mixed in as 10 required within ranges such that the object of the present invention is not impaired.

The film for fastening cargo during transportation according to the present invention exhibits effects of the ability to hold/fasten products during transportation being excellent, and 15 hence products not being damaged during transportation. Moreover, the film has a property of pinholes not being prone to occur in a pinhole resistance test.

### Examples

Following is a description of the present invention through 20 examples; however, the present invention is not limited by these examples whatsoever.

The percentage strain changes for the films obtained in the examples and for commercially sold films were measured in accordance with the following methods.

25 (1) Using a tensile test (ASTM-4), a load of 3.5MPa was applied to the film (size: thickness 80 $\mu$ m, length 64mm, width, 10mm) at

a temperature of 23°C, the strain after 100 hours was measured, and the percentage change in the strain relative to the initial strain was calculated.

(2) Using a tensile test (ASTM-4), a load of 0.5MPa was applied to the film (size: thickness 80μm, length 64mm, width, 10mm) at a temperature of 55°C, the strain after 100 hours was measured, and the percentage change in the strain relative to the initial strain was calculated.

(3) Using a tensile test (ASTM-4), the elastic modulus at a temperature of 23°C was determined.

(4) Using a tensile test (ASTM-4), the elastic modulus at a temperature of 55°C was determined.

(5) Using a Gelbo flex tester, a 205mm×180mm sample was twisted in a cylindrical shape 5000 times by 440° at a speed of 40times/min, and the number of pinholes in the sample was measured.

The interpolymers used in the examples were as follows.

#### Interpolymers

(1) Ethylene-styrene copolymer (interpolymer) (ESI-2008)

Styrene content: 25wt%

MFR (ASTM D 1238, 190°C, 2.16 kg load): 1.0g/10min

(2) Ethylene-styrene copolymer (interpolymer) (ESI-2408)

Styrene content: 30wt%

MFR (ASTM D 1238, 190°C, 2.16 kg load): 1.0g/10min

#### Example 1

Using a granulator, 100 parts by weight of the above-mentioned ethylene-styrene copolymer (ESI-2008; made by Dow

Chemical Company), 0.1 parts by weight of Irganox 1010 (trade name; phenolic antioxidant made by Ciba Specialty Chemicals), 0.1 parts by weight of Irgafos 168 (trade name; phosphor-based antioxidant made by Ciba Specialty Chemicals), 0.5 parts by weight of DICALITE  
5 WF (trade name; anti-blocking agent made by Grefco), and 0.5 parts by weight of Alflow P-10 (trade name; slipping agent made by NOF Corporation) were subjected to melt kneading, and pellets were prepared under the following granulating conditions.

<Granulating conditions>

10 Granulator: Kasamatsu 65mm single-screw extruder

L/D: 28

Mesh: 80/100/80

Screw diameter: 65mm

Rotational speed of screw: 45rpm

15 Extrusion amount: 28kg/hr

Temperatures of various parts: C1/C2/C3/C4/CH1/CH2/D =

160/170/190/190/190/190/190°C

Next, using an inflation molding machine, an 80 $\mu$ m-thick film was formed under the following film formation conditions from the  
20 pellets obtained as described above.

<Film formation conditions>

Molding machine: Inflation

L/D: 26

Screw diameter: 65mm

25 Rotational speed of screw: 37rpm

Extrusion amount: 36kg/hr

Die diameter: 100mm

Temperatures of various parts: C1/C2/A/D1/D2 =

180/180/190/190/190°C

Next, the elastic modulus, percentage strain change and  
5 pinhole resistance for the film obtained were determined following  
the methods described earlier. The results are shown in Table 1.

#### Example 2

The same was done as in Example 1, except that the  
above-mentioned ethylene-styrene copolymer (ESI-2408; made by Dow  
10 Chemical Company) was used instead of the ethylene-styrene  
copolymer (ESI-2008). The results are shown in Table 1.

#### Comparative Example 1

The same was done as in Example 1, except that a commercially  
sold 80µm-thick EVA film was used instead of the film obtained in  
15 Example 1. The results are shown in Table 1.

#### Comparative Example 2

The same was done as in Example 1, except that a commercially  
sold 80µm-thick urethane resin film was used instead of the film  
obtained in Example 1. The results are shown in Table 1.

20

Table 1

		Example 1	Example 2	Comparative Example 1	Comparative Example 2
Percentage strain change (%)	23°C	1.6	1.5	2.2	2.1
	55°C	2.3	2.1	2.8	3.9
Elastic modulus (MPa)	23°C	48	20	80	62
	55°C	12	6	27	25
Pinhole resistance (number of pinholes)		0	0	10	5

The following can be seen from Table 1. With Comparative Example 1 and Comparative Example 2, the percentage strain change obtained at a temperature of 23°C exceeded 2.0%, and the percentage strain change obtained at a temperature of 55°C exceeded 2.5%. If the percentage strain change is high in this way, then there may be a lack of ability to hold/fasten products (cargo) during transportation.

Moreover, with Comparative Example 1 and Comparative Example 2, the elastic modulus (at 23°C and at 55°C) was high, showing that the film was rigid and would be hard to fit to a product.

Moreover, in the pinhole resistance tests, with Comparative Example 1 and Comparative Example 2, pinholes were detected. With such a film, the film will be prone to tearing starting from a pinhole. On the other hand, with Example 1 and Example 2, the percentage strain change obtained at a temperature of 23°C was not more than 2.0%, and the percentage strain change obtained at a temperature of 55°C was not more than 2.5%. Moreover, the elastic modulus at 23°C was not more than 60MPa, and the elastic modulus at 55°C was not more than 20MPa. For a film that has a low percentage strain change and elastic modulus and has excellent pinhole resistance, the ability to hold/fasten products during transportation is excellent.